Work Order	ID	50319
------------	----	-------

Page 1

July 14, 2009 12:01:12 PM

Item ID:

D3151-3

Accept

Setup Start

Stop



**Revision ID:** C

Item Name: **Start Date:** 

**BRACKET** 

Start Qty: 4.00 7/15/09

Reg'd Qty: 4.00

**Cust Item ID:** 

**Customer:** 

Reference:

**Approvals:** 

Process Plan: MF

Date: 09-09-15 Tooling:

Date:

Start Run

Stop

Required Date: 7/15/09

Date: \_\_\_\_\_

SPC (Y/N):

Date:

Reject

Sequence ID/ **Work Center ID**  Operation Description Set Up/ **Run Hours**  Draw Number Draw Rev.

Plan Accept Code Qty

Reject Qty

Insp. Number Stamp

**Draw Nbr** 

**Revision Nbr** 

D3151

Rev C

100

Waterjet

FLOW WATER JET

Memo

0.00

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3151 Dwg Rev: C Prog Rev: C 2-

FB 9-8-B

110

QC2- Inspect parts off machine FAI/FAIB

Deburr if necessary

0.00

Memo

0.00

189-8-13

Quality Control

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00 => Sor/60/13

# **Dart Aerospace Ltd**

W/O:		WORK ORDER CH	WORK ORDER CHANGES				
DATE STEP		PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
<del></del>							

Part No: _	PAR #:	Fault Category:	NCR: Yes No	DQA:	Date:
			QA: N/C C	losed <sup>,</sup>	Date:

NCR:	WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC	Corrective Action Section B			Verification	Annuoval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector

July 14, 2009 12:01:12 PM

Item ID:

D3151-3

C

**Revision ID:** 

**BRACKET** Item Name:

**Start Date:** 

7/15/09

Start Qty: 4.00

Required Date: 7/15/09



Date: \_\_\_\_\_

Accept



Setup Start





**Cust Item ID:** Req'd Qty: 4.00 **Customer:** 

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop



Sequence ID/ **Work Center ID** 

130

Small Fab

Small Fab

Operation Description

Small Fab

Memo

Deburr D3151-3

Set Up/ **Run Hours** 

Draw Number

Draw Rev.

Plan Qty Code

Reject Accept Oty

Reject

Insp. Number Stamp

0.00



140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Chemical Conversion Coat per QSI005 4.1

Memo

150

HandFinish

=> X 4/80/PO /X C=

Memo

Hand Finishing

Dart Ae	rospace l	Ltd							
W/O:			WC	RK ORDER CHANGE	S				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	e Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
····,·									
Part No	:	PAR #:	Fault Cated	iory:	NCR: Yes	No DQ	<b>A</b> :	Date:	
								_ Date: _	
NCR:			WORK ORDE	R NON-CONFORMAN	ICE (NCF	R)		· · · · · · · · · · · · · · · · · · ·	
D. 4 7 P	0755	Description of NC		Corrective Action Section	В	Verific	cation	Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Secti		Chief Eng	QC Inspector
						į			

Work Order ID 5031	Vork O	rder	ID	503	1	9
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July 14, 2009 12:01:12 PM



Page 3

Item ID:

D3151-3

Accept

Setup Start



**Revision ID:** Item Name:

C

**BRACKET** 

7/15/09 **Start Date:** Required Date: 7/15/09

Start Qty: 4.00

Req'd Qty: 4.00

Operation

Description



Date:

**Cust Item ID:** 

**Customer:** 

Draw

Number

Reference:

Approvals:

Process Plan:

Date: **Tooling:** 

SPC (Y/N):

Date:

Draw

Rev.

Date:

Run

Start Stop

Stop

Reject

Number

Sequence ID/ **Work Center ID** 

160

QC

Memo

QC3- Inspect Part Finish

Set Up/ Run Hours

0.00

0.00

Qty

Accept

Plan

Code

an 09-08

Reject

Oty

Insp.

Stamp

Quality Control

170

Packaging Packaging

Memo

Identify as per dwg & Stock Location:

0.00

0.00



180

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

W 9.08.24

Dart Ae	rospace L	.td								
W/O:			WC	ORK ORDER CHAN	IGES					
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No	•	PAR #:	Fault Cate	gory:	NCF	R: Yes I	No DQ	<b>A</b> :	_ Date: _	
						QA: N/	C Close	d:	_ Date: _	
NCR:			WORK ORDI	ER NON-CONFORM	MANCE	(NCR	)			
DATE	STED	Description of NC		Corrective Action Se	ection B		Verific	ation	Approval	Approval
DATE	STEP Section A		Initial Chief Eng	Action Description Chief Eng	n	Sign & Date	Verification Section C		Chief Eng	QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
		Description of NC		Corrective Action Section B			Annroyal			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	- Verification Section C	Approval Chief Eng	Approval QC Inspector		
			-							
								:		
							1.11-20.1			

July 14, 2009 12:01:11 PM

Work Order ID: 50319

Parent Item:

D3151-3RevC

Parent Item Name: BRACKET



**Start Date: 7/15/09** 

Required Date: 7/15/09

Start Qty: 4.00

Required Qty: 4.00

**Comments:** Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Bin Primary Item Location Last Location

Route Seq ID Unit of Measure Hand

Qty Qty on Remaining **Qty To Pick** Issued

Date Issued

Status

M2024T3S.040

Purchased

No

100

sf

77.9100

2024-T3 .040 sheet

Warehouse	Loc Qty	Loc Code	
<b>Location</b>			
Main Warehous	e		
MAT	77.91		
11033	6.4		
11138	31 4		
11178	67.51		111786



# **Dart Aerospace Ltd**

	WORK ORDER CHANGES							
PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
correct st on Bom				69.08.24				
-					PROCEDURE CHANGE  By Date Qty Chief Eng / Prod Mgr			

Part No:	PAR #:	_ Fault Category:	NCR: Yes No DQA:	Date:
			OA: N/C Closed:	Data
			QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
		Description of NC		Corrective Action Section B			Annessal		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector	

D3065-5DART AEROSPACE LTD	Work Order:	50319
Description: Doubler Assembly	Part Number:	D3151-3
Inspection Dwg: D3151 Rev: C		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing	Tolerance	Actual	Accept	Reject	Method of	Comments
Dimension	Tolerance	Dimension	Accept	Reject	Inspection	
Ø0.098	+0.004/-0.001	,099	8			
Ø0.250	+0.005/-0.001	676,	d			
Ø0.700	+0.008/-0.001	,701	<b>&gt;</b>			
2.75	+/-0.030	7.784	➣			
6.76	+/-0.030	6.761	*			
6.060	+/-0.010	6.068	¥			
1.075	+/-0.010	1.076	k			
3.305	+/-0.010	3,307	*			
0.350	+/-0.010	,351	*			
0.688	+/-0.010	-686	<b>*</b>			
0.344	+/-0.010	343	*			
1.480	+/-0.010	i.480	x			
2.150	+/-0.010	2148	¥			
3.800	+/-0.010	3.800	*			
1.975	+/-0.010	1.974	<b>½</b>			
0.350	+/-0.010	.351	کھ			
0.475	+/-0.010	<b>.</b> ዛገገ	<b>≫</b>			
1.800	+/-0.010	1.798	<b>)</b> 20			
2.050	+/-0.010	2,648	<b>&gt;</b>			
1.375	+/-0.010	1374	P			
ī						

Measured by:	B	Audited by: $\int_{\cdot}$		Prototype Approval:	N/A
Date:	9-8-13	Date: 🖎	08/13	Date:	N/A

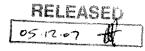
Rev	Date	Change	Revised by	Approved
Α	08.05.20	New Issue	KJ/DD X	N/
			771	<b>-</b>

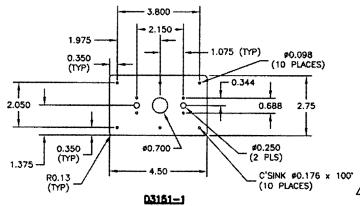


	DESIG	n RF	DRAWN BY RF	DART AEROSPACE LT HAWKESBURY, ONTARIO, CANADA	D	***************************************	
ı	CHEC	(ED a.L.	APPROVED ()	DRAWING NO.		REV.	7
		世	#	D3151 shi	EET	1 OF	1
-	DATE			TITLE		SCAL	
	05.1	2.07		DOUBLER ASSEMBLY		1:4	ı
	Α		02.04.23	NEW ISSUE			1
	В		04.09.08	RE-DESIGN			
	С		05.12.07	REVISE NOTES			



## D3151-041 DOUBLER ASSEMBLY REPLACES PREMIER P/N B30-23000-173/-174





SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 50319 MF 09-07-15

3.800 -1.480 2.150 1.975 Ø0.250 #0.098 (2 PLS) 0.350 (14 PLS) (TYP) 0.344 2.75 2.050 1.800 0.688 0.350 0.475 **#0.700** - 1.075 1.375 - 3.305 RO.13 6.060 (TYP) 6.76

03151-3

## NOTES

- 1) MATERIAL: 2024-T3 SHEET (QQ-A-250/4) 0.040" THICK (REF. DART SPEC. M2024T3S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N D3151-041 USING FINE POINT PERMANENT INK MARKER

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